

Date: Tuesday, 17/02/2009 10:18:56 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BALL JOINT ROD END
<b>Job Number</b> : 45822	
<b>Estimate Number</b> : 12440	
<b>P.O. Number</b> :	<b>Part Number</b> : D35183
<b>This Issue</b> : 17/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3518 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 39029	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/02/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.02.17</u>	
<b>Comment</b> : Est Rev:A New Issue 06-11-22 JLM est rev B rev b dwg 07.04.09 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	2458K14	rod end
-----	---------	---------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
rod end

2.0	PG	PURCHASING
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**Comment:** Issue P/O: 8198  
 Purchase Part Number: 2458K14  
 Supplier: Mc Master Carr  
 Certificate of conformity is required

C209/02117

(20)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure certificate of conformity is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



**Comment:** DIMENSIONAL CHECK

09/02/19 (20)  
 2090220 (20)  
 05P019

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: ST106

09/02/23 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:56 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL JOINT ROD END

Job Number: 45822

Part Number: D35183

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

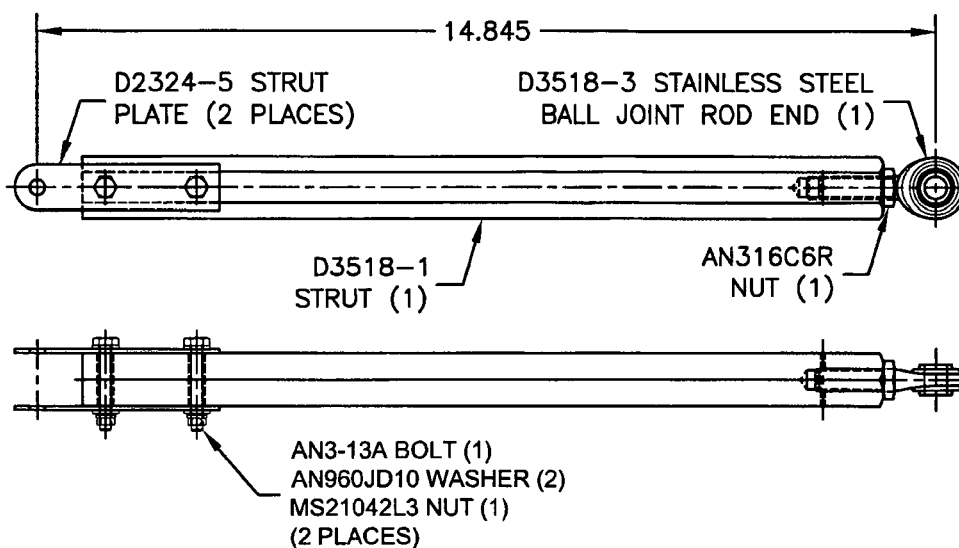
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 1 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3
A	06.06.21	NEW ISSUE	
B	06.10.23	RE-DESIGN	



### D3518-041 STRUT ASSEMBLY

QTY	Part Number	Description
-041		
X	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

#### NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER NO. *65822*

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WITHOUT NOTICE  
WORK ORDER

RELEASED

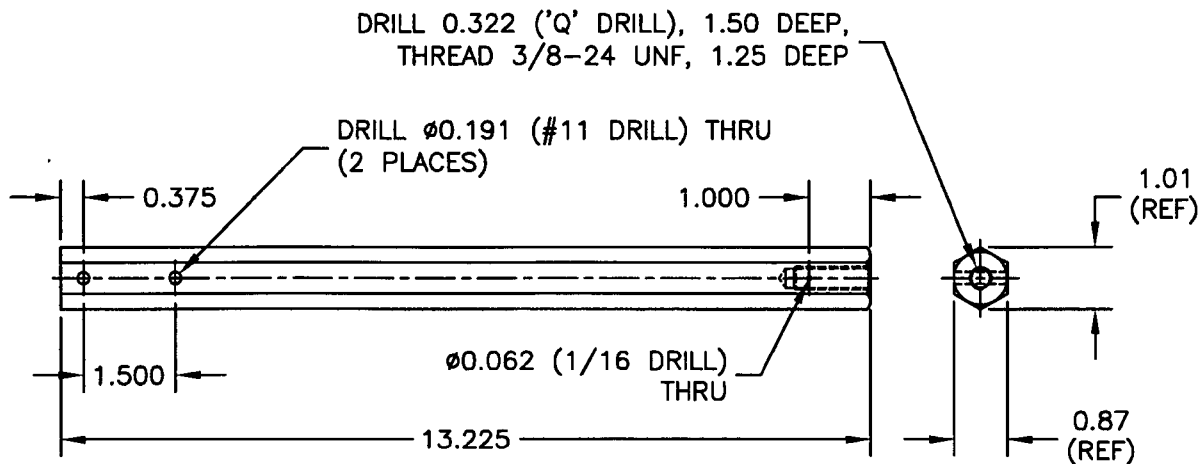
06.11.17 *[Signature]*

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**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3518	REV. B SHEET 2 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3

**D3518-1 STRUT****NOTES:**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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WITHOUT NOTICE  
WORK ORDER  
NO. 45822

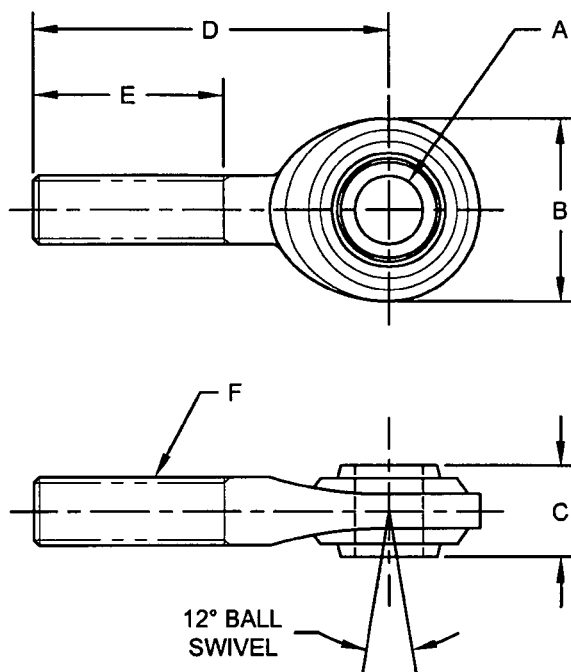
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 3 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:1

## SPECIFICATION CONTROL DRAWING



DART P/N	A	B	C	D	E	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF, RH	4012	McMASTER-CARR, P/N 2458K14

\* Indicated load is Static Radial Load Capacity in lbs

### NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END, NOT TO AMENDMENT
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE. (OUT NOTICE)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.11.17 *[Signature]*

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# DART

## Purchase Order

Date Feb 17, 2009	Page 1
Purchase Order Number PO00008198	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

FAKED  
(613)632-1053

**Vendor Address:**

McMaster-Carr Supply Co,  
P.O. Box 7690  
Chicago, IL 60680-7690  
USA  
Phone (330) 995-5500  
Fax (330) 995-9600

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VU-MCM001	Feb 17, 2009	N30	Purolator	Feb 20, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
2.0000	9613T24	LIGHT BULB	20/02/2009	No	5.290000	Each	10.58
2.0000	75975A658	2 WAY TAPE	20/02/2009	No	20.500000		41.00
20.0000	2458K14	rod end	20/02/2009	No	5.390000		107.80
		Comments: AS PER DWG D3518 REV. B MCMaster P/N: 2458K14 B45822					
4.0000	1931T47	TWINE COTTON	20/02/2009	No	9.880000		39.52

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

**Comments:****Tax Summary:**

Less:	
included tax	0.00
Subtotal	198.90
Total tax	0.00
Total purchase order in	
USD Dollars	198.90

Entered By: CLAVOIE

Approved By:



200 Aurora Industrial Parkway  
Aurora OH 44202  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada  
Attention: Main Finished Goods Location

Purchase Order  
PO00008198

McMaster-Carr Number  
3411350-01

Page 1 of 1

02/17/2009

Line	Description	Ordered	Shipped		
1	9613T24 Miniature Halogen Bulb, #h3, 12 Volt, 55 Watt	2 Each	2	3 - 58 - 01 04 - 46 T24	2 EA 1
2	75975A658 Removable Vinyl Tape-Adhesive Both Sides, 1" Wide X 72 Yards Long	2 Rolls	2	1 - 458	2
3	2458K14 Carbon-Fiber Race Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 4012 Pound Load Capacity	20 Each	20	3 - 483	3
4	1931T47 Twisted Comfort-Grip Cotton Twine, Polished, 1-lb Ball, .116" Diameter, 115# Break Strength, 320' L	4 Each	4	3 - 272	4

## Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog.

*Jason Wolfe*  
Jason Wolfe  
Compliance Manager

Dart Aerospace Ltd

Assembly  
Area

12

Cycle

48

Shelf

209

Documents

4

SS-R-0707

5

EXP

7 lbs  
4 lines

FW1BSP61  
02/17/2009  
14:26/14:42  
884

9004852648009

